

MAY 13 2013

Work Order ID 132296

132296

Page 1

Item ID: D2528-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Backer Plate

Start Date: 5/06/15 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/15/15 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2528

Rev C1

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2528 Dwg Rev: C1 Prog Rev: C1 2-
Debur if necessary

(12)

DC 15/05/07

5052 . 063

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(12)

DC 15/05/07

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(12)

DAS
38
9-89

MAY 07 2015

132296

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/06/15 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 5/15/15 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Chemical Conversion Coat per QSI005 4.1

0.00

130

Memo

0.00

HandFinish

Hand Finishing

QAS

28

MAY 13 2015

9-8

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

140

Memo

0.00

Powdercoat

Powder Coating

START TIME:

~~OVEN TEMPERATURE:~~

FINISH TIME:

105.

150

QC3- Inspect Part Finish

0.00

150

Memo

0.00

QC

Quality Control

Work Order ID 132296

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Item ID: D2528-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Backer Plate
 Start Date: 5/06/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/15/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: ST-007	0.00				12			MAY 13 2015
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MCS MAY 14 2015

Picklist Print

May-06-15 11:28:18 AM

Page 1

Work Order ID: 132296

132296

Parent Item: D2528-1

D2528-1

Parent Item Name: Backer Plate

Start Date: 5/06/15

Required Date: 5/15/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: C00.06.26Removed P/O for powder coatEC
IPP Rev:D 08-07-23 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased	No			100	sf	30.2849	0.0303	1			

M5052H32S 063

5052-H32 .063 Sheet

215/05/07

Location

Loc Qty

Loc Code

MAT022

30.2849

M128455

30.2849

7



DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	05.04.27	1.46 WAS 1.460; 1.00 WAS 1.000	

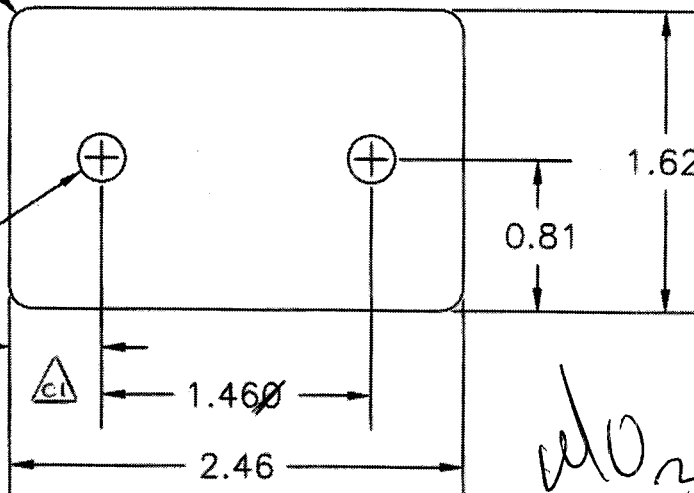
RELEASED
98.12.11 *KE*

R0.13 (TYP)

UNDER REVIEW
[Signature]
OK *[Signature]* 03.12.03

Ø0.257 (TYP)

0.50

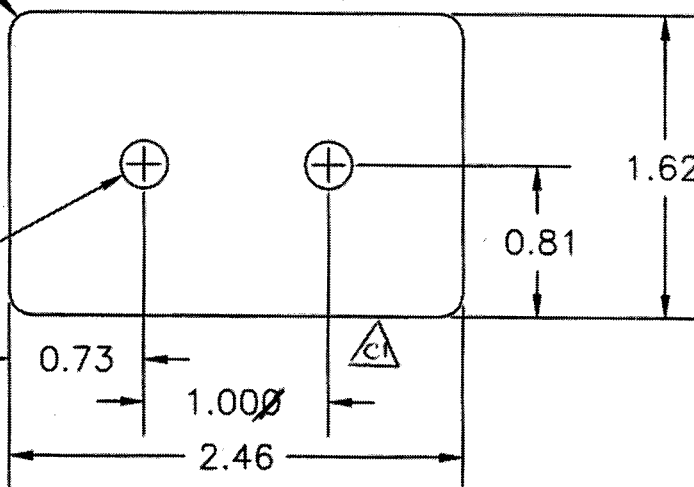


D2528-1

R0.13 (TYP)

Ø0.257 (TYP)

0.73



D2528-3

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED